

Date: Tuesday, 18/12/2007 7:55:46 AM
 User: Linda Lacelle

Process Sheet

Sprint

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: PANEL
Job Number	: 36401-1	Part Number	: D32452
Estimate Number	: 10872	Drawing Number	: D3245 REV B
P.O. Number	:	Project Number	: N/A
This Issue	: 18/12/2007	Drawing Revision	: B
Prsht Rev.	: NC	Material	:
First Issue	: //	Due Date	: 10/01/2008
Previous Run	: 35651	Qty:	6
Written By	:	Um:	Each
Checked & Approved By	:	<i>M</i>	<i>5</i>
Comment	: Est. A 04.07.07 New issue KJ/JLM Est Rev:b ECN 1052 07-10-31 DD verified by:		

Additional Product

SCRAP

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304S22GA	304/316 .032 Sheet <i>6.7536</i>
		Comment: Qty.: 0.8442 sf(s)/Unit Total : 5.0652 sf(s) 304/316 .032 Sheet Batch: <i>106419 1B 07-12-18</i>
2.0	WATER JET	FLOW WATER JET
		Comment: FLOW WATER JET 1-Cut as per Dwg D3245 ****prog.D3245-1-2**** Dwg Rev: <i>B</i> Prog Rev: <i>B</i> <i>1B 07-12-18</i>
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE <i>1B 07-12-18</i>
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE
4.0	QC8	SECOND CHECK
		Comment: SECOND CHECK
5.0	BRAKE NC	NC BRAKE
		Comment: NC BRAKE Deburr if necessary C'sink as per Dwg D3245 Form D3245-1 as per Dwg D3245 Identify as D3245-1 <i>ml 08/03/19 x 20</i>
		<i>8/12/18 X7</i>
		<i>ml 08/03/19 x 20</i>
		<i>8/12/18 X7</i>
		<i>ml 08/03/19 x 20</i>
		<i>8/12/18 X7</i>

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3245-2 PAR #: N/A Fault Category: Prod sn/mad. NCR: Yes No DQA: AS Date: 08.12.04
 SCRAP | SCRAP QA: N/C Closed: AS Date: 08/12/04

NCR: 36401		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng.	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/12/04	#	Re fill in holes that were counter sunk too Deep. Human error L.O.A.	AS1012	fill in hole with weld Per QST004	AS1012	08/12/04	AS1012	AS1012
			AS1012	Curing flux remove holes	AS1012	08/12/04	AS1012	AS1012
			AS1012	Re counts sink Scrap, destr. No replace	AS1012	08/12/04	AS1012	AS1012

NOTE: Date & initial all entries

Date: Tuesday, 18/12/2007 7:55:46 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PANEL

Job Number: 36401

Part Number: D32452

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

8.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-12-02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	36401
Description: PANEL	Part Number:	D3245-2
Inspection Dwg: D3245-2 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Measured by:	LB	Audited by:	<i>[Signature]</i>	Prototype Approval:	<i>n/a</i>
Date:	07-12-18	Date:	7/12/19	Date:	<i>[Signature]</i>

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

8

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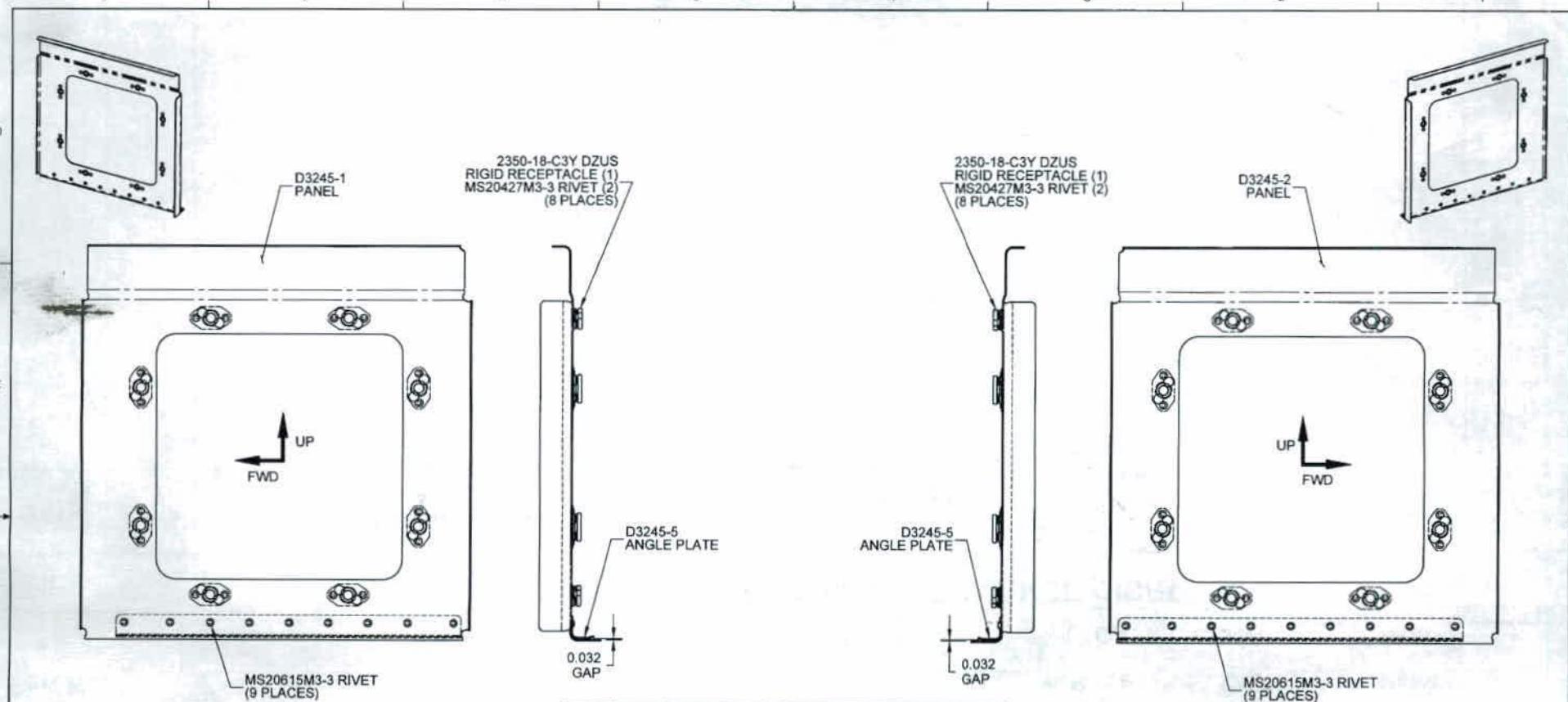
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D3245-041 ACCESS PANEL ASSEMBLY

RELEASED
07-10-02

10/10/02

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3245-XX" AND B/N "BXXXXX" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.83 lbs

QTY -041	QTY -042	P/N	DESCRIPTION
X	X	D3245-041	ACCESS PANEL ASSEMBLY, LH
1	1	D3245-042	ACCESS PANEL ASSEMBLY, RH
1	1	D3245-1	PANEL
1	1	D3245-2	PANEL
8	8	2350-18-C3Y	DZUS RIGID RECEPTACLE
16	16	MS20427M3-3	RIVET
9	9	MS20615M3-3	RIVET

D3245-042 ACCESS PANEL ASSEMBLY

B	REMOVE Ø0.204 HOLES FROM D3245-1/-2. REMOVE MS210M3-L3K NUTPLATES & DURABLA BLACK GASKETS FROM D3245-1/-2. HOLES AND ITEMS ARE NOW PART OF INSTALLATION. ASSIGN P/Ns TO GASKETS & REFORMAT DRAWING	MB	07.10.02
A	NEW ISSUE	RF	04.01.27
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>PH</i>	DART AEROSPACE LTD	
DRAWN	<i>PH</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>PH</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>PH</i>	D3245	SHEET 1 OF 7
APPROVED	<i>PH</i>	TITLE	SCALE
DE APPR.	<i>PH</i>	ACCESS PANEL ASSEMBLY	1:2.5
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

8

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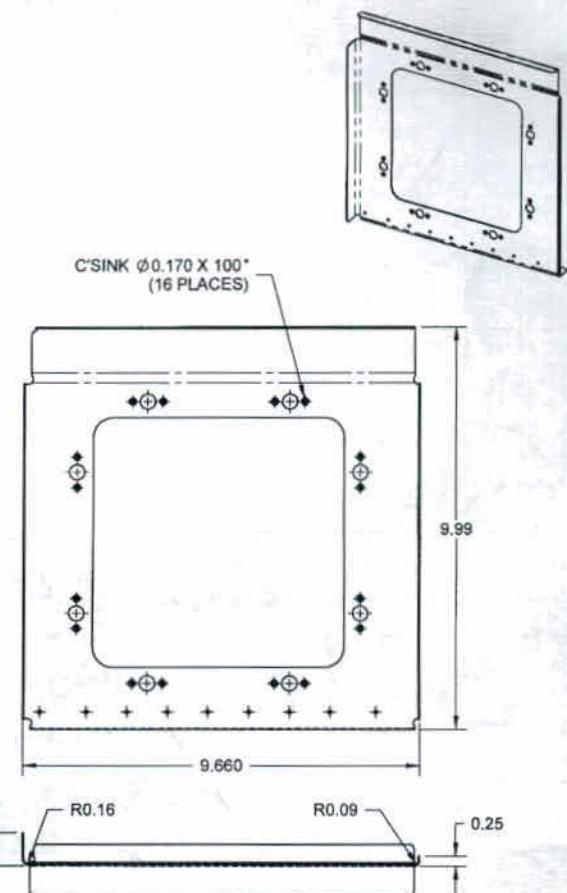
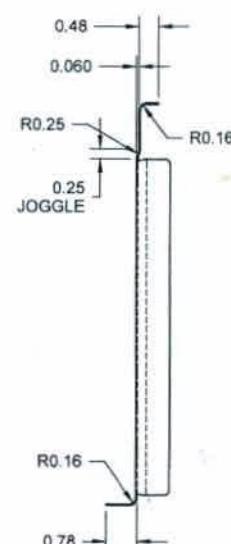
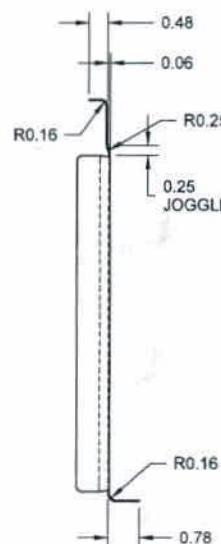
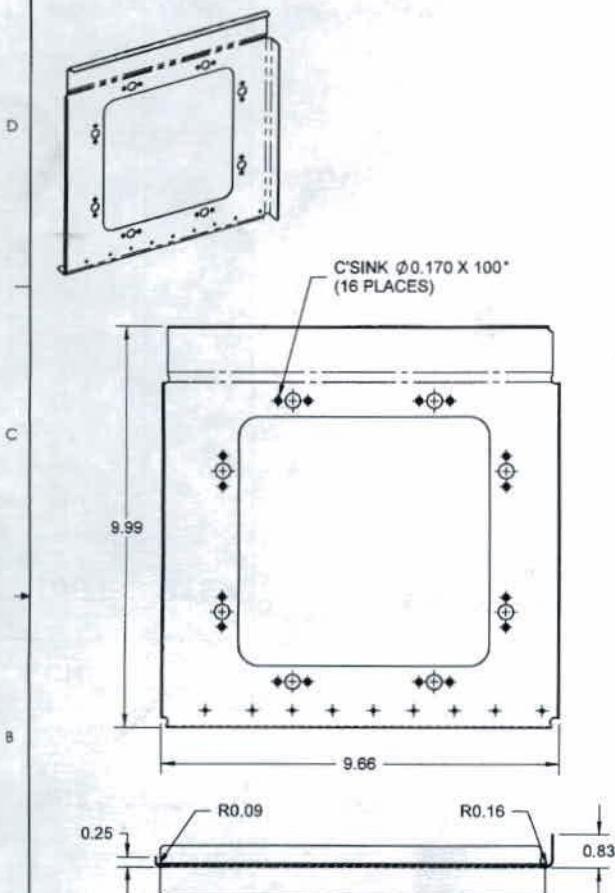
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RELEASED
10-10-23

NOTES:

- 1) MATERIAL: MAKE FROM D3245-1F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.70 lbs

DESIGN	<i>JF</i>	DART AEROSPACE LTD
DRAWN	<i>AS</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>PH</i>	DRAWING NO.
MFG. APPR.	<i>AS</i>	REV. B
APPROVED	<i>AS</i>	SHEET 2 OF 7
DE APPR.	<i>AS</i>	TITLE
DATE	07.10.02	SCALE
		ACCESS PANEL ASSEMBLY 1:3

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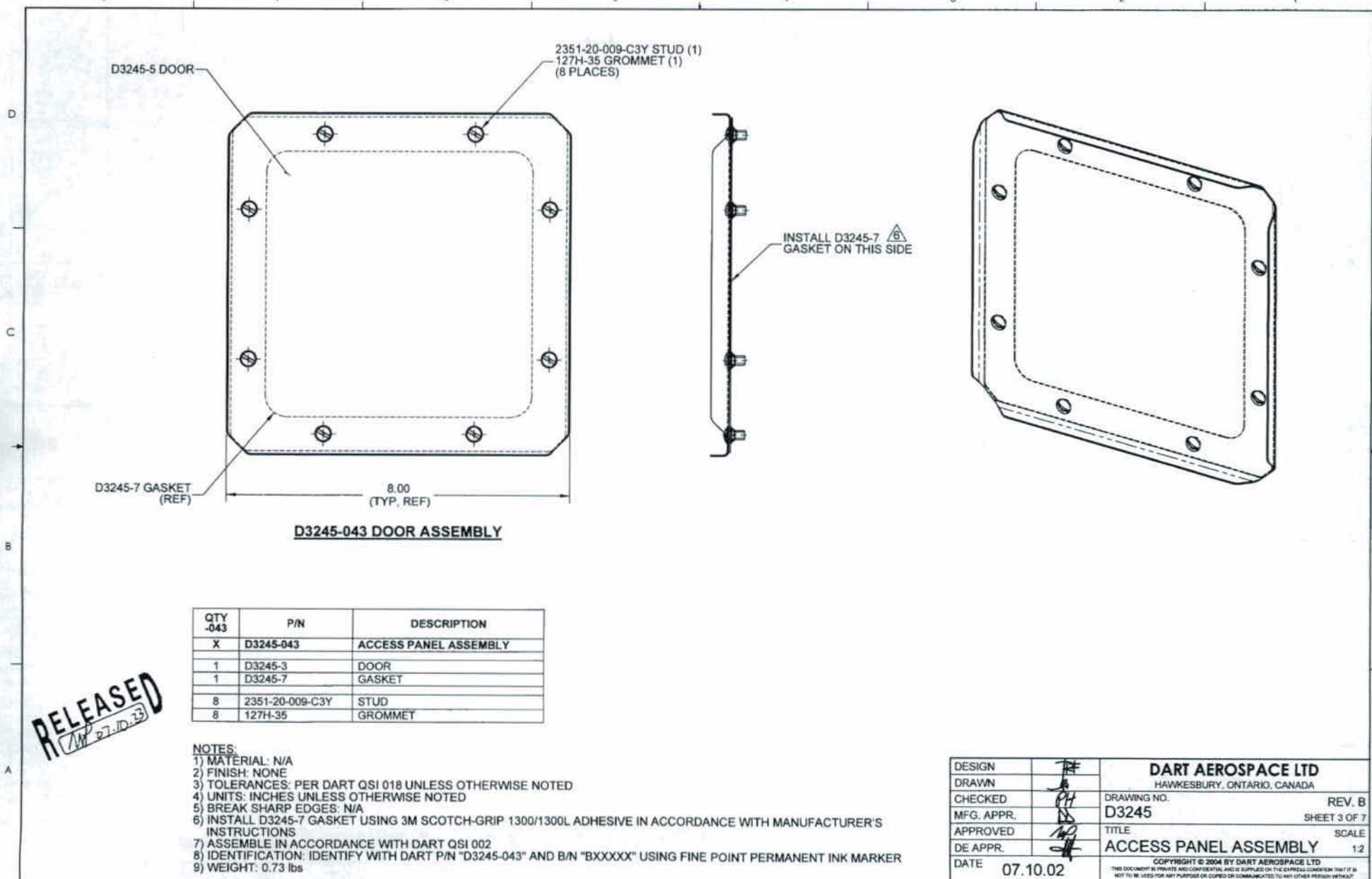
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD
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CHECKED	<i>[Signature]</i>	DRAWING NO.
MFG. APPR.	<i>[Signature]</i>	REV. B
APPROVED	<i>[Signature]</i>	D3245
DE APPR.	<i>[Signature]</i>	SHEET 3 OF 7
DATE	07.10.02	TITLE
		SCALE
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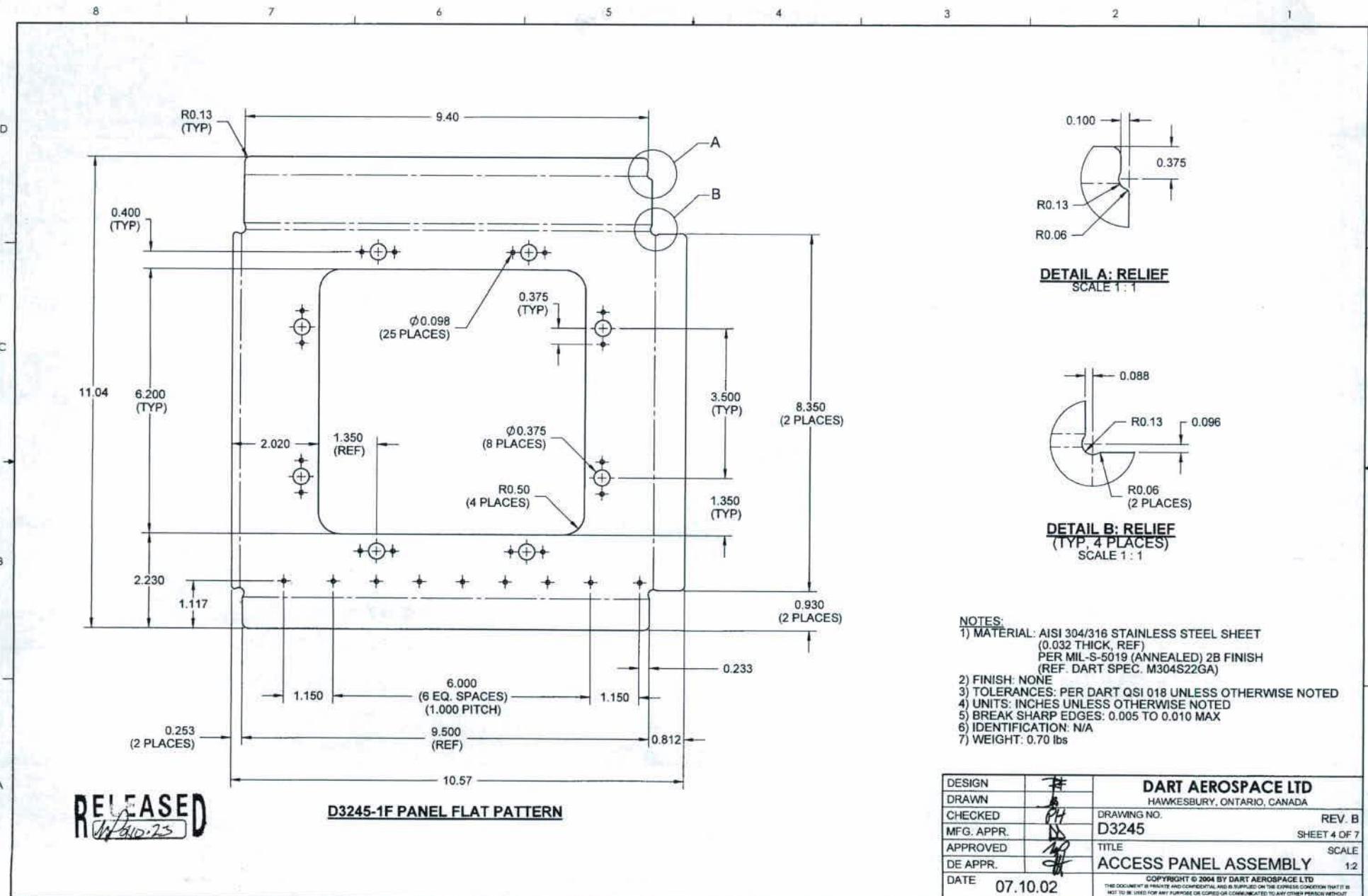
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



RELEASED
10/10/23

D3245-1F PANEL FLAT PATTERN

NOTES

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET
(.032 THICK, REF)
PER MIL-S-5019 (ANNEALED) 2B FINISH
(REF. DART SPEC. M304S22GA)

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: .0005 TO 0.010 MAX

6) IDENTIFICATION: N/A

7) WEIGHT: 0.70 lbs.

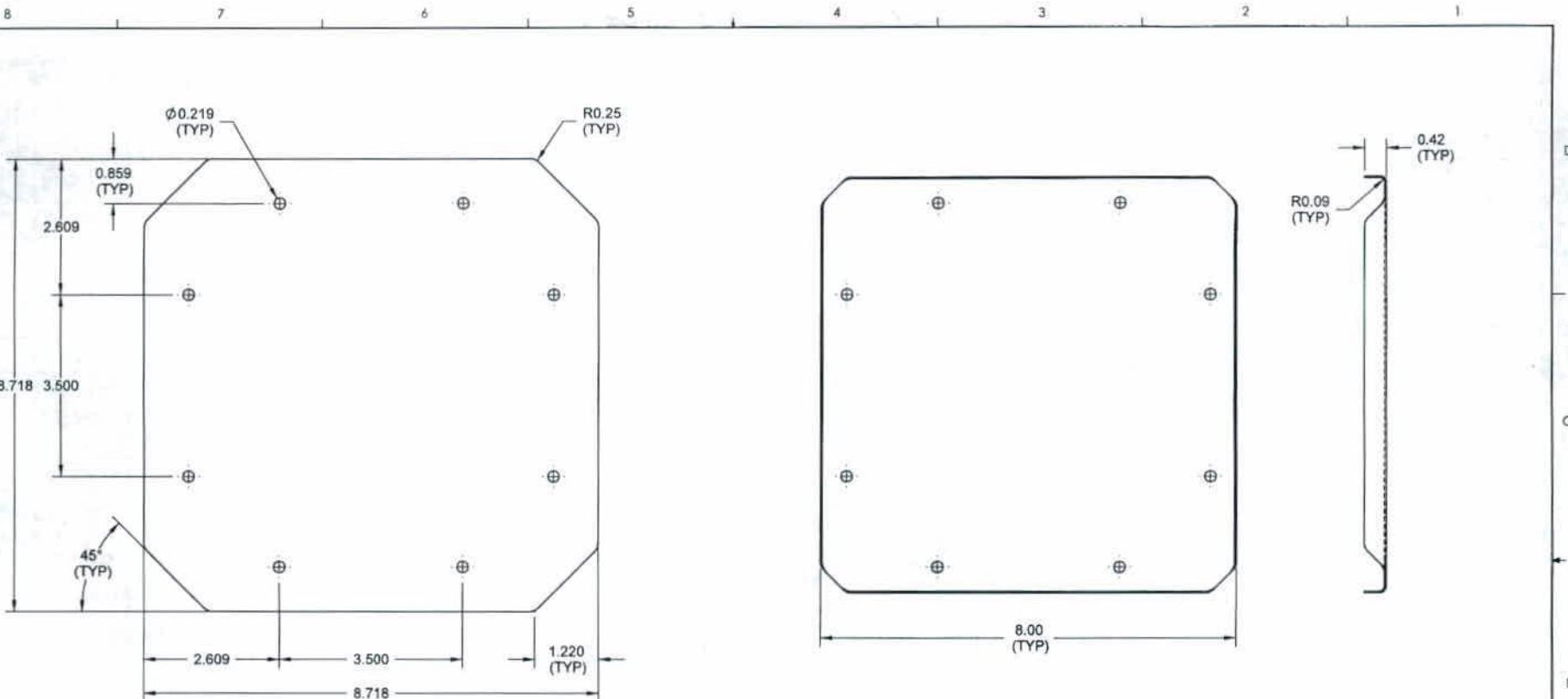
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DRAWN	<u>A</u>			
CHECKED	<u>PH</u>	DRAWING NO.	REV. B	
MFG. APPR.	<u>DS</u>	D3245	SHEET 4 OF 7	
APPROVED	<u>SP</u>	TITLE	SCALE	
DE APPR.	<u>SP</u>	ACCESS PANEL ASSEMBLY	1:2	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3245-3F DOOR FLAT PATTERN

D3245-3 DOOR BENDING DETAIL

RELEASED
07-10-02

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET (0.032 THICK, REF PER MIL-S-5019 (ANNEALED) 2B FINISH (REF. DART SPEC. M304S22GA))
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.67 lbs



DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD
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MFG. APPR.	<i>[Signature]</i>	D3245
APPROVED	<i>[Signature]</i>	SHEET 5 OF 7
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D C B A

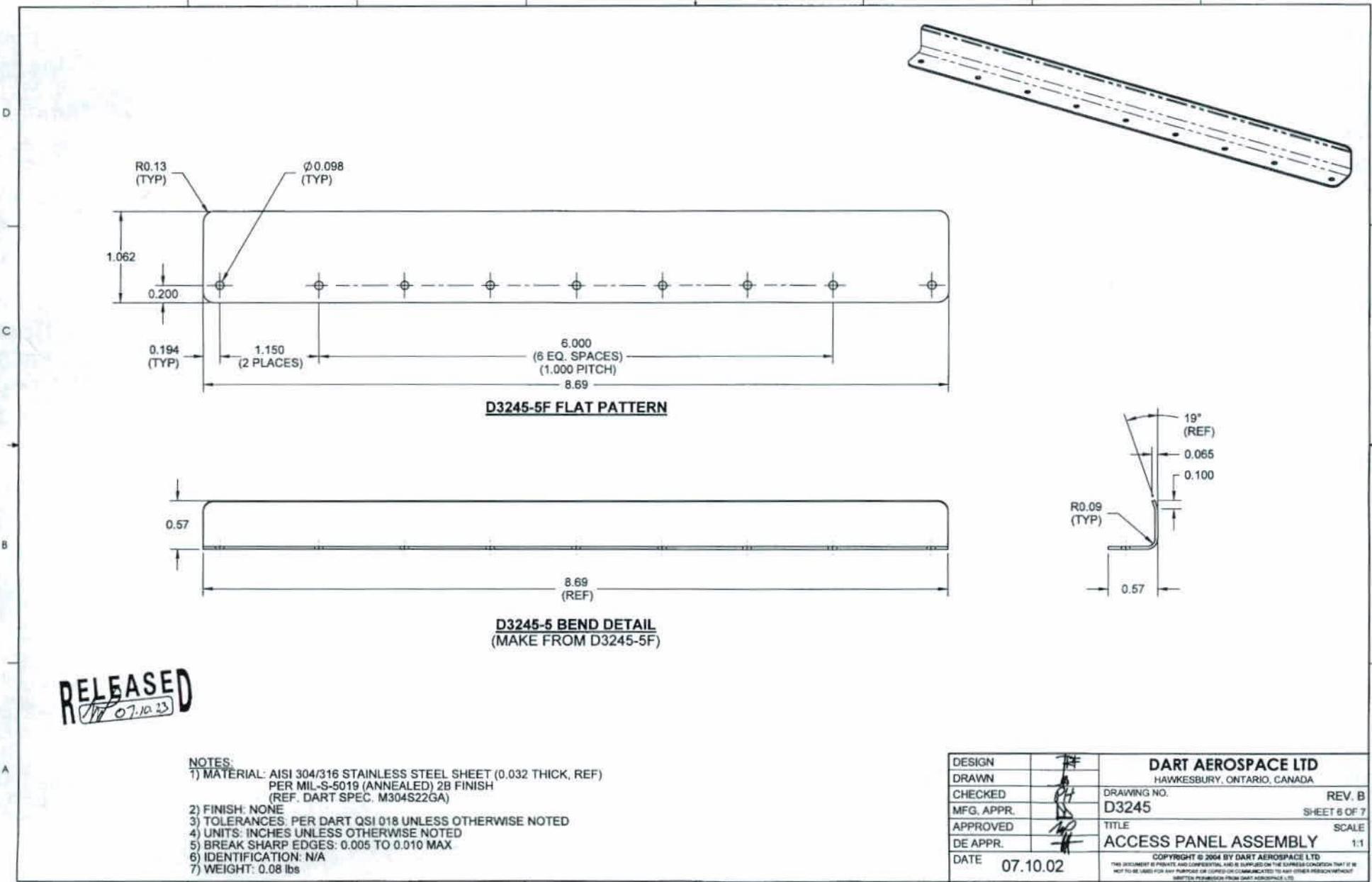
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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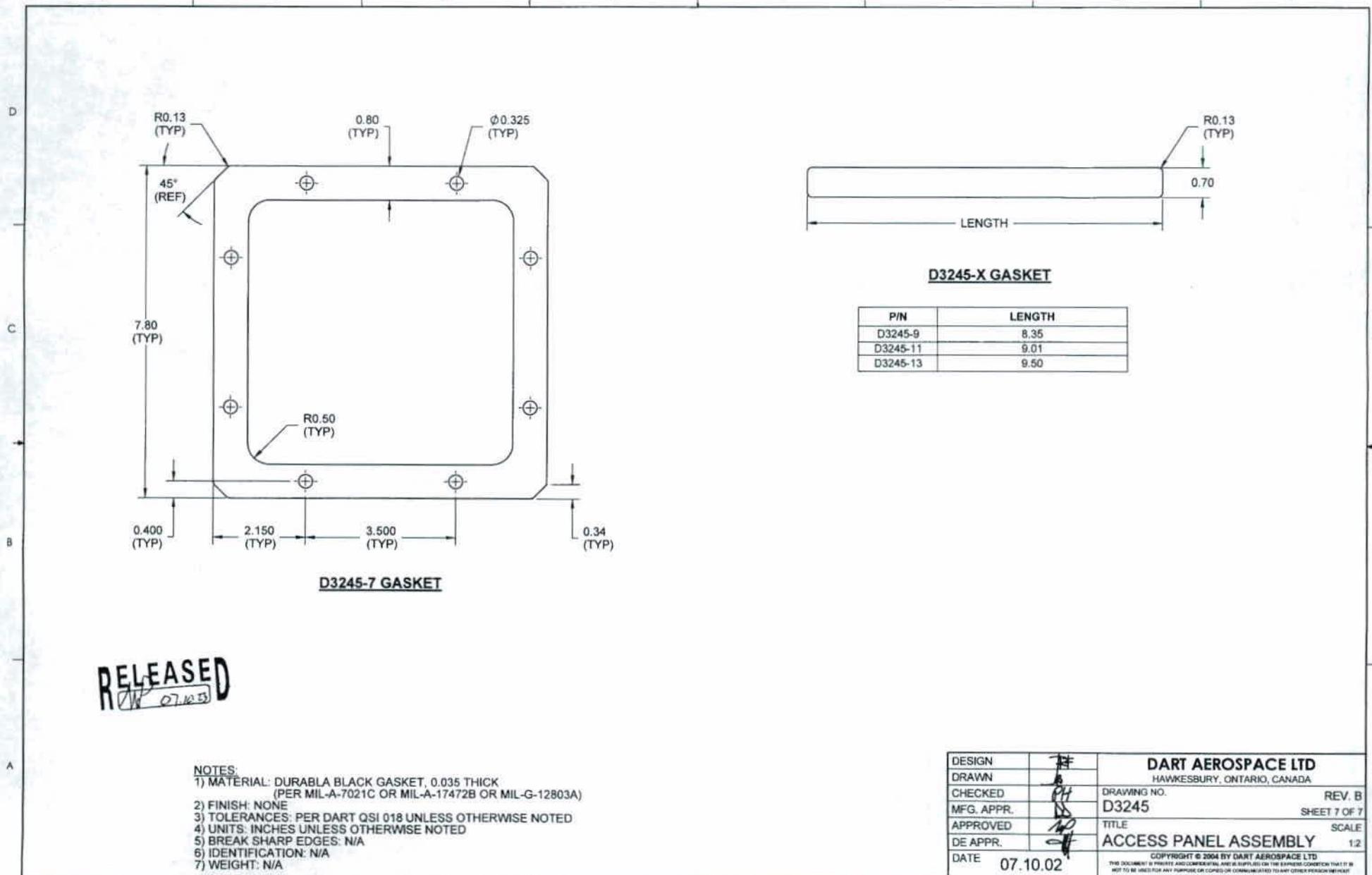
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



8 7 6 5 4 3 2 1



DESIGN	1	DART AEROSPACE LTD
DRAWN	1	HAWKESBURY, ONTARIO, CANADA
CHECKED	PH	DRAWING NO.
MFG. APPR.	1	REV. B
APPROVED	1	D3245
DE APPR.	1	SHEET 7 OF 7
DATE	07.10.02	TITLE
		SCALE
		1:2

ACCESS PANEL ASSEMBLY

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